

Date: Thursday, 19/10/2006 10:57:08 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 29075  
Estimate Number : 11036  
P.O. Number :  
This Issue : 19/10/2006 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1/ Type : R & D SM/MED FAB  
Previous Run : 27561  
Written By :  
Checked & Approved By :  
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Drawing Name : BRACKET ASSEMBLY - UNDER REVIEW  
Part Number : D2804041  
Drawing Number : D2804 REV B  
Project Number : N/A  
Drawing Revision : UNDER REVIEW  
Material :  
Due Date : 20/10/2006 Qty: 2 Um: Each

**PRELIMINARY ISSUE**

*Handwritten notes:*  
- 1  
- OK per attached DS encl  
- 06.10.20

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28041	STA 155 Bracket
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) STA 155 Bracket Pick: Qty Part Number Description Batch 1 D2804-1 Bracket B 29076 MF 06/10/20		
2.0	D28051	Stop
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Stop Pick: Qty Part Number Description Batch 1 D2805-1 Stop B 27616 MF 06/10/20		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-1 into arm as per Dwg D2804 MF 06/10/20		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP Dec. 10.20		
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 MF 06/10/20 (3)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/10/2006 10:57:08 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY - UNDER REVIEW

Job Number: 29075

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06/10/20

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Press D2809 into arm as per Dwg D2804

MF 06/10/20

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

1101884

MF 06/10/20

9.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

1

D2809

Bushing

B 28629

MF 06/10/20

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21043-3

Nut

1100218

MF 06/10/20

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

1100993

A/R

LPS-3


Corrosion Spray

1101472

MF 06/10/20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/10/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/10/2006 10:57:08 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY - UNDER REVIEW

Job Number: 29075

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

mf. 06/10/20  
mf - 06/10/20 (2)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10-20 (2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 4/10/20 (2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2006/10/20 (2)

Job Completion



UL 10-10-20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD		Amendment Design Review (ADR) Yes/No:		ECN #: 865
Date: 06-10-19		ADR Date:		
Job No: 00075		Created By: P	Checked By:	
Product No: D412-630		Approved By:	Approved By:	
Product Name:		(Proj. Manager)	(Management if reqd)	

## Documents Affected:

RELEASE D2804 Rev C Preliminary Issue

#	Engineering Actions	Yes	No	Responsible	To happen by:	Complete
1	Required Documents/Drawings Under Review?	✓				
2	Update Blue/Pink Folder/Electronic File		✓			
3	Update DSI Folder/Electronic File		✓			
4	Update D-Part Master Binder		✓			
5	Update Grey Project Binder		✓			
6	Update DEO/DSI Binder		✓			
7	Update Master Document List (MDL)		✓			
8	Update Document Record (DR)		✓			
9	Update Change Record Form		✓			
10	Move Electronic File		✓			
11	Notify TC of Change		✓			
12	Notify FAA of Change		✓			
13	Update QSI 021 (TC/FAA STC)		✓			
14	Update QSI 036 (K-Kits)		✓			
15	Update Accpac Database		✓			
16	Update Access Database		✓			
17	Verification ARC		✓			
18	Update STC Approval List		✓			
19	Update Product Development Summary		✓			
20	Create/Update COSS (Estimate/BOM)	✓		JLM/EC		
21	Create/Update PPP's		✓			
22	Update Paperwork Kits in Production		✓			
23	Update Paperwork Kits in Stock		✓			
24	Red Tag Stock with old CHG #		✓			
25	Rework/Scrap Current Production		✓			
26	Rework/Scrap Kits in Stock?		✓			
27	Update Qpulse/Laminated Dwgs		✓			
28	Create/Update Controlled PDF Files		✓			
29	Create/Update FAI sheets	✓		JLM/EC		
30	Create/Update CNC Programs	✓		JLM/EC		
31	Create/Update Tooling	✓		JLM/EC		
32	MPP required?		✓			
33	Notify Previous Customers	✓		CP		
34	Notify Eurocopter France		✓			
35						
36						

## Description / Action:

- WE NEED QTY(1) D2804-041, finished and assembled ASAP
- LL: we need QTY(1) D2803-041 (MADE TO D2803 Rev B) and QTY(1) D2804-041 (MADE TO D2804 Rev C Prelim. Issue) READY TO SHIP TO CUSTOMER FRIDAY 20th

ECN Complete: \_\_\_\_\_ Date: \_\_\_\_\_

## Chris Provencal

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**From:** Chris Provencal [cprovencal@dartaero.com]  
**Sent:** October 18, 2006 4:33 PM  
**To:** David Shepherd (David Shepherd)  
**Subject:** Emailing: IIN-D412-630-RevK.pdf

**Attachments:** QR-D412-630-2a.pdf; D2804-c.pdf; IIN-D412-630-RevK.pdf



IIN-D412-630-RevK D2804-c.pdf (211  
.pdf (2 MB) KB)

David,

Here is the stuff so you can (hopefully) approve the new D2804 bracket. I'll send the remaining docs later tonight. I moved the affected area down by 3/8". I'll be returning to Dart in a few hours so I'll make any changes you need. I'll send the file to JLM as soon as I get an OK from you.

-Chris



## Chris Provencal

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 19, 2006 11:18 AM  
**To:** 'Chris Provencal'  
**Subject:** RE: D412-630 problem again

I agree. Your new design should be good.

Thanks Chris

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Thursday, October 19, 2006 8:46 AM  
**To:** David Shepherd (David Shepherd)  
**Subject:** FW: D412-630 problem again  
**Importance:** High

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**From:** S Shahbazian [mailto:sshahbazian@dartaero.com]  
**Sent:** October 6, 2006 12:46 PM  
**To:** Provencal, Chris  
**Subject:** FW: D412-630 problem again  
**Importance:** High

**Serge Shahbazian**  
Design Manager  
Dart Aerospace Ltd.  
Tel: 613-632-3336

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**From:** Natalie Taitt [mailto:nataliet@dartaero.com]  
**Sent:** October 6, 2006 12:22 PM  
**To:** Jason Loader; David Shepherd; 'Dan Stow'; Bill Beckett; Serge Shahbazian (E-mail)  
**Cc:** 'Chantelle Toppin'  
**Subject:** FW: D412-630 problem again  
**Importance:** High

Good Afternoon,

This is the second problem the customer has with his steps. Please see the below email. Is it possible for us to have an answer for him today?

P.S. – how are we progressing with the first problem he advise us on (Oct 3, 2006)?

Thanks!

*Natalie Taitt*  
*Sales Associate*  
**DART Helicopter Services**

20/10/2006